



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2807-041
Job Sheet 187843



Part No: D2807-041

Job Qty: 4 ea

Part Name: Prop Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	4 pcs	1/28/19	1/28/19	0.00	0.00	Purchasing		JAN 15 2019
110	Packaging	4 pcs	1/28/19	1/28/19	0.00	0.00	Packaging2		JAN 15 2019
120	QC	4 pcs	1/28/19	1/28/19	0.00	0.00	QC6		38 DAS
130	Small Fab	4 pcs	1/28/19	1/28/19	0.00	0.08	Small Fab-2		DAS-89 36
140	QC	4 pcs	1/28/19	1/28/19	0.00	0.00	QC5		36 9-89
150	Packaging	4 pcs	1/28/19	1/28/19	0.00	0.00	Packaging3-1	STOLL	9-89 FEB 04 2019
160	QC21-SA	4 Ea	1/28/19	1/28/19	0.00	0.00	QC21		FEB 04 2019

Part Op 100 - Issue P/O: 642075 Order as per Dwg D2807 Possible supplier: Lift Support
Descriptions: Technologies, Saskatoon, Canada P/N 6/15-164/50-115N
110 - Ensure Material Release Note is attached
130 - 1-install D3671-1 as per dwg D2807

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6/15-164/50-115N	Gas Spring D2807-041	4 pcs (1 ea)	100-Purchasing	5144943
D3671-1	Placard	4 Ea (1 ea)	130-Small Fab	5120045 3x 5146225 (1x)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	6/15-164/50-115N	4	0	0
130-Small Fab	D3671-1	4	27	0



Container No: S144945



Part: D2807-041

Job No: 187843

Serial No/Batch: S144945

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ns

be found.

Plex 12/17/18 2:50 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

SPECIFICATION CONTROL DRAWING

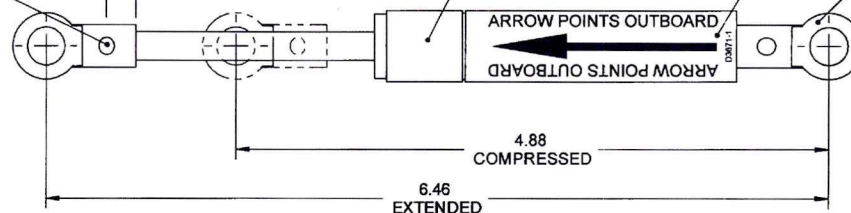
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

RELEASED
08-12-11

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2) (WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-1/3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JE		
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	JE	D2807	SHEET 1 OF 3
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	GAS SPRING	NTS
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042075



Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

PO No: PO042075
PO Date: 12/17/18
Due Date: 1/15/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187789	SSA4/8-122-310-360N			Gas Spring D3969-3 As Per Dwg D3969	Firmed	-	1/8/19	10 pcs	0 pcs	10 pcs	\$81.65/pcs	\$816.50
							10 X	JAN 15 2019					
2	187788	B8-154-382-050N			Gas Spring D5479-1 As Per Dwg D5479 Rev. A	Firmed	-	1/8/19	6 pcs	0 pcs	6 pcs	\$40.06/pcs	\$240.36
							6 X	JAN 15 2019					
3	187843	6/15-164/50-115N			Gas Spring D2807-041 As per Dwg D2807 Rev. E	Firmed	-	1/8/19	4 pcs	0 pcs	4 pcs	\$72.13/pcs	\$288.52
							4 X	JAN 15 2019					
												Grand Total:	\$1,345.38

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 1/9/19 3:51 PM dart.tsimiklis.chrisoula

Packing Slip

LS TECHNOLOGIES INC
1634 Saskatchewan Ave
Saskatoon, SK S7K 1P6

P.O. No.	Date	Invoice #
042075 ✓	1/9/2019	19584

Bill to:

Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship to:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship	Via
1/9/2019	Fed-Ex

Qty	Description
✓ 10	D3969-3 #187789 Stainless Gas Spring (SSA4/8-122-310-360N) LABELLED WITH PERMANT INK MARKER ONLY - NO LABELS
✓ 6	D5479-1 #187788 Gas Spring
✓ 4	D2807-041 #187843 Stainless Gas Spring (6/15-164/50-115N)
	Shipping Via FED EX Tracking # 774160718217

DAS
38
9-89

Order checked by :





LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Jan 10, 2019

This is to certify that the parts listed below meets specifications as required by your order.

- ✓ 10 Units: D3969-3 #187789 Stainless Gas Spring
- ✓ 6 Units: D5479-1 #187788 Gas Spring
- ✓ 4 Units: D2807-041 #187843 Stainless Gas Spring

Country of Manufacture: Canada

Date of Manufacture : Jan 2019

This product is ROHS compliant.

Purchase Order # **042075**

Invoice # 19584

L S Technologies Inc Canada

Nolan Fehr
President

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